

Date: Friday, 22/08/2008 1:54:20 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VALVE ASSEMBLY (1/4")
Job Number : 41593	
Estimate Number : 10962	
P.O. Number :	Part Number : D20014
This Issue : 22/08/2008 S.O. No. :	Drawing Number : D2001 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 38056	Material :
Written By :	Due Date : 28/08/2008 Qty: 12 Um: Each
Checked & Approved By : <u>JUL 08 8:22</u>	
Comment : Est. A 04.07.06 New Issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 7010

P/N: 76-101-32 (1/4 NPT)

Possible Supplier: Flo-Control Inc.

Material release note is required

C 208/08/22

(12)

2.0	7610132	VALVE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 VALVE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

R 8/26 (12)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

S 08/08/27 (12)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Remove existing ID numbers and replace with Dart P/N & B/N

EP 08/08/27 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VALVE ASSEMBLY (1/4")

Job Number: 41593

Part Number: D20014

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 08/08/27 (12)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST02

SS 08/08/27 (12)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(12)

D20014

Job Completion



MF 08-08-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

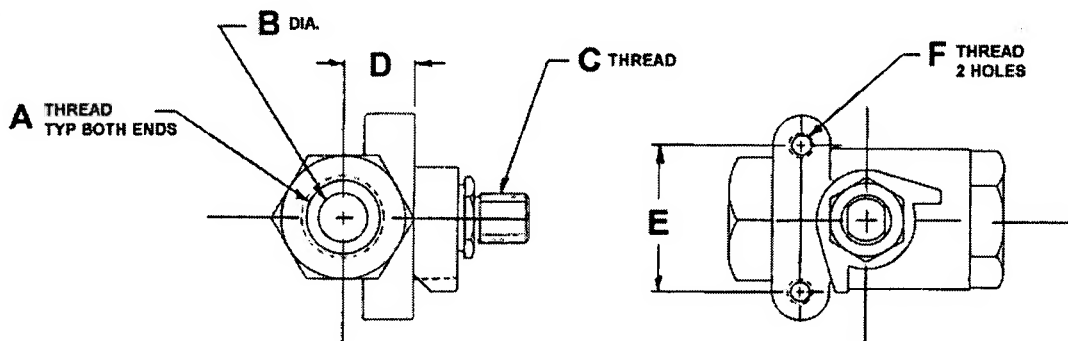
NOTE: Date & initial all entries



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2001	REV. C SHEET 1 OF 1
DATE 04.07.06		TITLE VALVE ASSEMBLY	SCALE NTS
-	90.04.02	NEW ISSUE	
A	92.05.12	-043 ADDED	
B	96.04.10	DART P/N CHG,041-6,042-12,ADD -16	
C	04.07.06	ADD D2001-4	

RELEASED
04.07.06

SPECIFICATION CONTROL DRAWING



Dart P/N	Apollo P/N	A	B	C	D	E	F
D2001-4	76-101-32	1/4 NPT	0.370	3/8-24 NF	0.56	1.120	10-24 UNC
D2001-6	76-102-01	3/8 NPT	0.370	3/8-24 NF	0.56	1.120	10-24 UNC
D2001-8	76-103-01	1/2 NPT	0.500	3/8-24 NF	0.60	1.120	10-24 UNC
D2001-12	76-104-01	3/4 NPT	0.680	7/16-20 NF	0.79	1.370	10-24 UNC
D2001-16	76-105-01	1 NPT	0.870	7/16-20	0.99	1.370	10-24 UNC

NOTES:

- 1) POSSIBLE SUPPLIER: FLO-CONTROL INC. OR APOLLO VALVE DIVISION
- 2) DISCARD HANDLE AND ATTACHING NUT, EXCEPT FOR D2001-4
- 3) CHECK DIMENSION SHOWN ON THIS DRAWING
- 4) REFERENCE INFORMATION:

MATERIAL: 316 STAINLESS STEEL
INVESTMENT CAST COMPONENTS
MEETS NACE-MR-01-75
MEETS WW-V-35C TYPE II, COMP SS, STYLE 3
PRESSURE RATING: 2000 PSI @ 100°F
150 PSI @ 400°F

- 5) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41593

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Conbraco Industries, Inc.
701 Matthews Mint Hill Rd.
Matthews, NC 28105
(704) 847-9191



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Plt(s) STC Pcs

Sold to:		Ship To:		** ORIGINAL **		
FLO-CONTROL INC 80 CENTER RD CARTERSVILLE UNITED STATES GA 30121		DART AEROSPACE LTD 1270 ABERDEEN ST HAWKS BURY CANADA ON K6A1K7		Pieces: 1 Weight: 9.40 PPD/COL: C Packed By: RUSTYC Pack Date: 8/25/08 Shipped By: STAR Ship Date: 8/25/08 PRO# ASN# 67075000003133078		
Customer Number:	Customer Order:	Order Number:	Date Received:	Salesman:	Ship Via/Instructions:	
01004667	60763	C368744	8/25/08	4	FP01 FDX ACCT# 15179324-0	
Line Number	Part Number	Part Description	Quantity Ordered	Quantity Shipped	Unit	Customer Part Number / Comments
1000	7610132A	CONTACT TAG PO# P000007010 AT PHONE:	12	12	EA	
1049	CERTIF01	BV, 1/4"NPT, SS, SS TEE HNDL CERTIFICATE OF COMPLIANCE SHIPPING LOCATION:	1	0	EA	Certificate of Compliance N/C

S
02/08/07

PACKING SLIP